

Work Order ID 103102

June-13-13 12:54:53 PM

shp 19/06

103102

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Item ID: D2199-25 Accept *N900040100* Setup Start *NS1*
 Revision ID: *prod* Stop *NS2*
 Item Name: Strut
 Start Date: 6/13/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/17/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: *u* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	Rev E1								
100	NC BRAKE	0.00							<i>FF</i>
100									
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg D2199 and Spec Control Dwg D2638								
110	Small Fab	0.00							<i>FF</i>
110									
Small Fab	Memo	0.00							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4 *0* *13-06-13*

4 *0* *13-06-13*

u

27
13 6 14

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Item ID: D2199-25 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 6/13/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/17/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Memo START TIME: 12-10 OVEN TEMPERATURE: 400 OF FINISH TIME: 12-40	0.00							4X ✓ M-J 13/06/14
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00							4
	Memo 21 13624	0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 5264	0.00							4X ——— SD 13-6-14
	Memo	0.00							

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Item ID: D2199-25

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 6/13/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/13

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop ***NR2***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

13/6/17 

ME
13-6-14

Picklist Print

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Work Order ID: 103102

Parent Item: D2199-25

Parent Item Name: Strut

Start Date: 6/13/13

Required Date: 6/17/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	480.1769	1.66	6.9894737		FF 13-06-13	

Location

Loc Qty

Loc Code

MAT017

480.1768825

122312

13.3

122468

0.0000325

124768

83.93245

125068

93.9444

125513

289

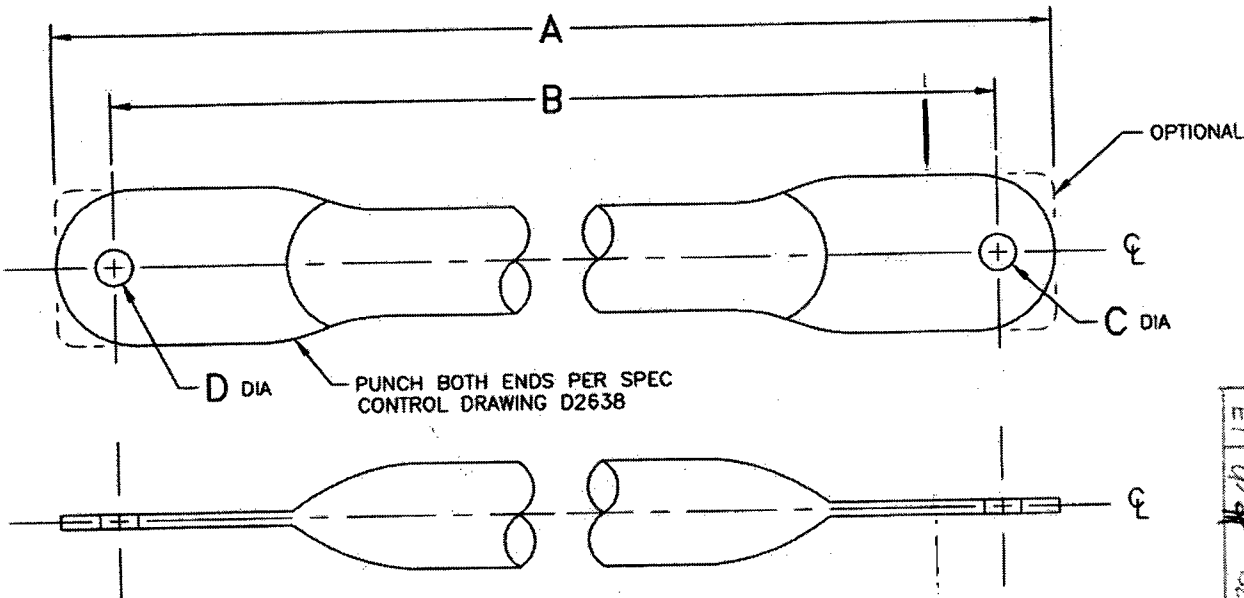
6.9894



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		D2199	SCALE
98.04.28		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	98.05.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

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W/O 103602

100.10.13
100.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (43.52) PER DART Q51.005 43.52